

Date: Thursday, 11/12/2008 10:44:58 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET LID, RH)
Job Number : 44019	
Estimate Number : 13663	
P.O. Number :	Part Number : D3836042
This Issue : 11/12/2008 S.O. No. :	Drawing Number : D3836 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 22/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JD 08.12.11</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:eC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer Bushing

Batch: B35605

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 1.8698 f(s)/Unit Total : 7.4794 f(s)

304 SQ Tube .75x.75x.065W

batch: MICOLL

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- drill hole in D3836-2 as per dwg D3836 using DT9436 jig

3- remove identification markings

4- deburr

SAD

08-12-29

SAD

08-12-29

SAD

08-12-29

SAD

08-12-29

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- weld D3836-2 to D3836-3 as per dwg D3836 using DT9447 welding jig

****after welding ensure measurements are good****

2- weld D2327-3 spacer bushing as per dwg D3836

SAD

09-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:44:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 44019

Part Number: D3836042

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R ER316 S.S. Rod Batch: P1106762

3- grind weld flush where indicated on dwg D3836

4- deburr if necessary

09-01-05

6.0

QC9

VISUAL WELDING INSPECTION



(x8)

Comment: VISUAL WELDING INSPECTION

P109-01-06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S09/01/06 (x8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STEVE G.

AS 09/01/06 (x8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

AS 09/01/06

Job Completion



MF 09-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

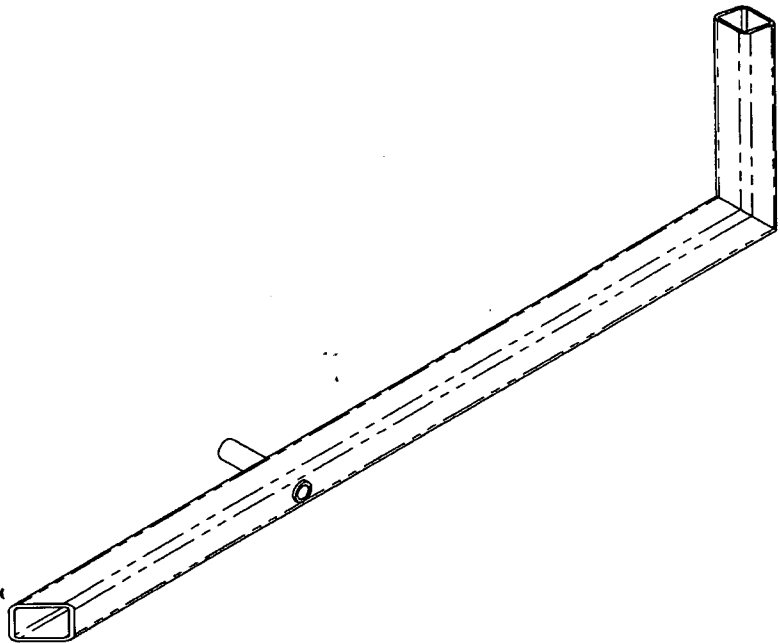
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

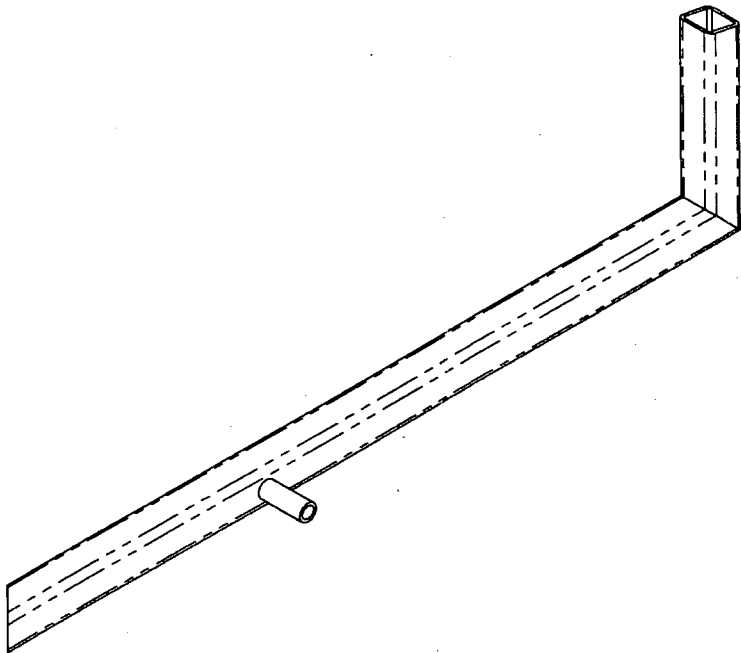
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



D3836-042 RIB ASSY (BASKET LID, RH)



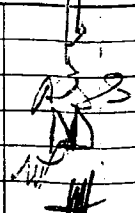
D3836-041 RIB ASSY (BASKET LID, LH)

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4409

RELEASED
08/11/18 MB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

A	NEW ISSUE		MB	08.09.24
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3836	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		RIB ASSY (BASKET LID)	NTS	
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD		
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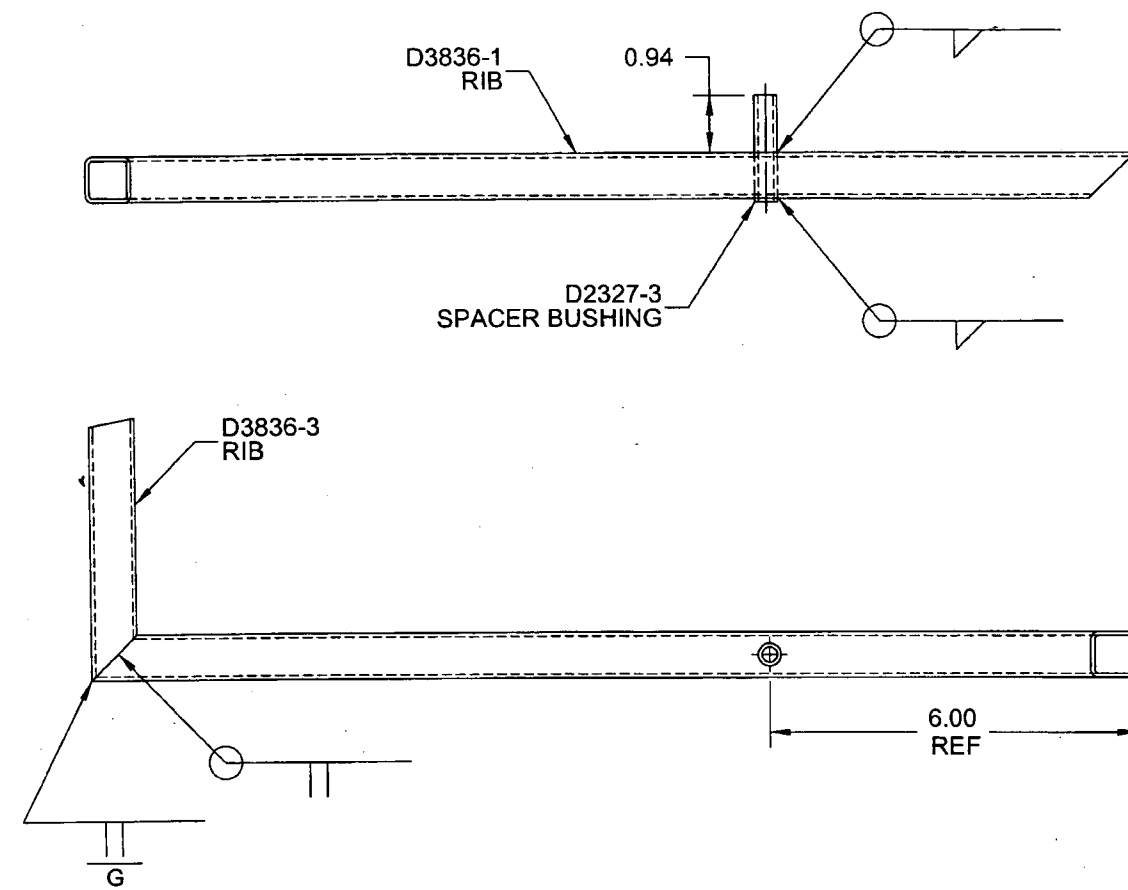
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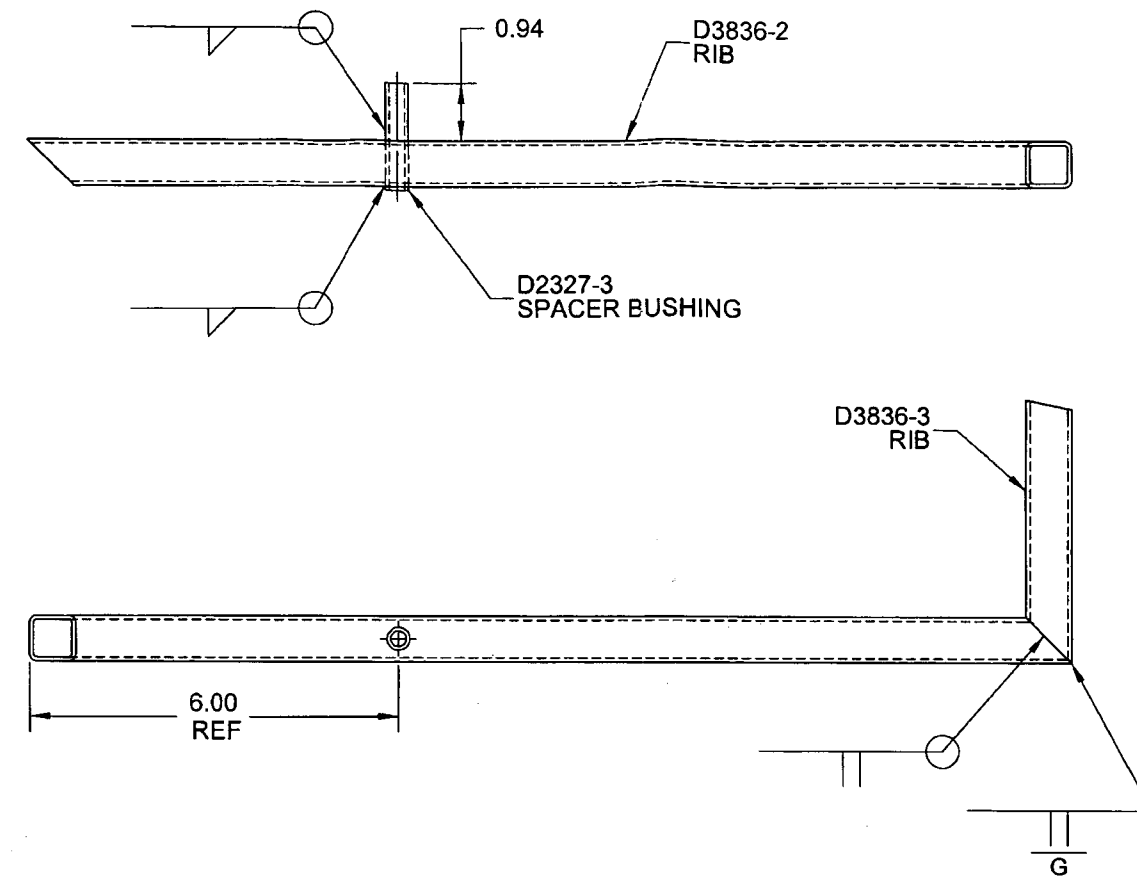
C

B

A







D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

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RELEASED
08/11/18 JWP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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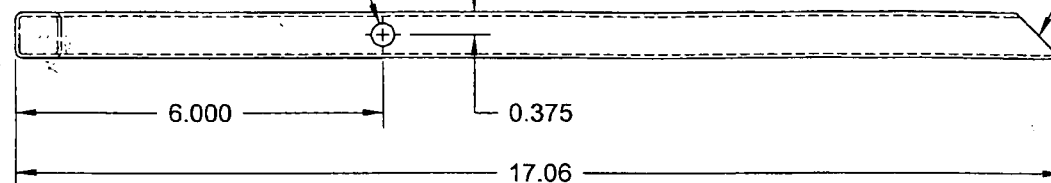
8 7 6 5 4 3 2 1

21

0.75 X 45°
CHAMFER



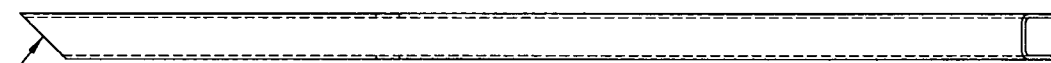
$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



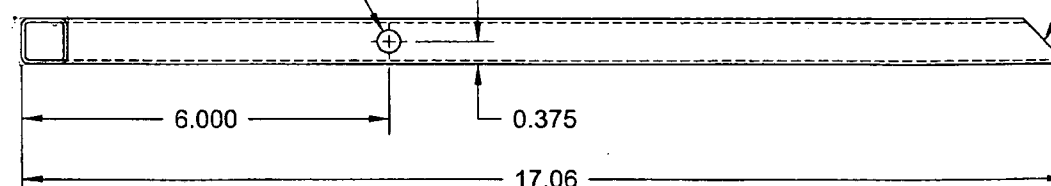
0.75 X 45°
CHAMFER

D3836-1 RIB

0.75 X 45°
CHAMFER

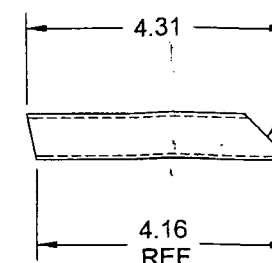


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU



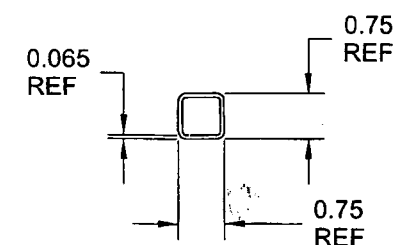
0.75 X 45°
CHAMFER

D3836-2 RIB



0.75 X 45°
CHAMFER

D3836-3 RIB



**TYPICAL SECTION
VIEW**

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SUBJECT TO AMENDMENT
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NO. 4409

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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